

Please cancel claims 10-11 and 18-27, without prejudice.

1. (Amended) A cooling roll for manufacturing a ribbon-shaped magnetic material by colliding a molten alloy to a circumferential surface of the cooling roll so as to cool and then solidify the molten alloy, the cooling roll comprising:

gas expelling means defined by at least one groove provided in the circumferential surface of the cooling roll for expelling gas entered between the circumferential surface and a puddle of the molten alloy;

wherein the average width of the groove is $0.5 - 90 \text{ }\mu\text{m}$.

3. (Amended) The cooling roll as claimed in claim 1, wherein the outer surface layer of the cooling roll is formed of a material having a heat conductivity lower than the heat conductivity of the structural material of the roll base at room temperature.

5. (Amended) The cooling roll as claimed in claim 2, wherein the outer surface layer of the cooling roll is formed of a material having a heat conductivity equal to or less than $80 \text{ W m}^{-1}\text{K}^{-1}$ at room temperature.

6. (Amended) The cooling roll as claimed in claim 2, wherein the outer surface layer of the cooling roll is formed of a material having a coefficient of thermal expansion in the range of $3.5 - 18 [\times 10^{-6} \text{K}^{-1}]$ at room temperature.

12. (Amended) The cooling roll as claimed in claim 1, wherein the average depth of the groove is 0.5 – 20 •m.

13. (Amended) The cooling roll as claimed in claim 1, wherein the angle defined by the longitudinal direction of the groove and the rotational direction of the cooling roll is equal to or less than 30 degrees.

14. (Amended) The cooling roll as claimed in claim 1, wherein the groove is formed spirally with respect to the rotation axis of the cooling roll.

15. (Amended) The cooling roll as claimed in claim 1, wherein the at least one groove includes a plurality of grooves which are arranged in parallel with each other through an average pitch of 0.5 – 100 •m.

16. (Amended) The cooling roll as claimed in claim 1, wherein the groove has openings located at the peripheral edges of the circumferential surface.